5/03

DART AEROSPACE LTD	3/	Work Order:	22080
Description: Doubler/ Mount Angle/ Filler		Part Number:	D3208-1/-3/-7
Dwg: D3208 Rev. A page 1, 2		Qty:	4
			Page 1 of 1

DC	Step	Location	Procedure	Ву	Date	Qty
Dwg not required	1			4	17/ 5 - A	1
Cut blank: 2038" x 5.340" grain along 4.038" Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Identify for D3208-1 Batch: M 16 30 2 CPL 04-12-15 A		本04.26.08	·	471	04,12.08	4
Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Identify for D3208-1 Batch: M 16 30 2 PL 04-12-15 4				10		
Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Material: 6061-T6 (QQ-A-250/11) 0.063" thick M16302 QPL 04-12-15 QPL	2	GA				
Identify for D3208-1 Batch:			(MO00ATOC 040)	ŀ		
GA			Identify for D3208-1 Batch: M 16 30 2	rDI	04.17-15	4
Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Identify for D3208-7 Batch: M16302 CPL 04-12-15 4	3	GΔ	Cut blank: 2 750" x 4 300"		04-12-13	
(M2024T3S.040) Identify for D3208-7 Batch: M16302 QL 04-12-15 GA Cut blank: 1.651" x 5.250" grain along 1.651" Material: 6061-T6 (QQ-A-250/11) 0.063" thick (M6061T6S.063) Identify for D3208-3 Batch: M15510 (M6061T6S.063) Identify for D3208-3 Batch: M15510 PL 04-12-15 GA Drill and Fillet D3208-1 corner as per Dwg D3208 Identify as D3208-1 GA Drill and Fillet D3208-7 corner as per Dwg D3208 Identify as D3208-3 corner as per Dwg D3208 Identify as D3208-3 GA Deburr D3208-3 corner as per Dwg D3208 Identify as D3208-3 GA Deburr D3208-1/-3/-7 GB Form D3208-1 as per Dwg D3208 10 GB Form D3208-3 as per Dwg D3208 11 QC5 Inspect work to Step 10 12 FP Chemical Conversion Coat as per QSI 005 4.1 13 QC3 Inspect Conversion Coat D3208-1 Qty D3208-3 Qty D3208-3 Qty D3208-7 Qty D3		0, 1				
Identify for D3208-7	•		(M2024T3S 040)			4
Material: 6061-T6 (QQ-A-250/11) 0.063" thick M 15510 (M6061T6S.063) Identify for D3208-3 Batch:			Identify for D3208-7 Batch: <u>M 16 30 2</u>	CPL	04-12-15	•
Color 168.063 Identify for D3208-3 Batch:	4	GA	Cut blank: 1.651" x 5.250" grain along 1.651"			
Color 168.063 Identify for D3208-3 Batch:	İ		Material: 6061-T6 (QQ-A-250/11) 0.063" thick /// 10510			
5 GA Drill and Fillet D3208-1 corner as per Dwg D3208 CFI O4-12-15 4 6 GA Drill and Fillet D3208-7 corner as per Dwg D3208 CFI O4-12-15 4 7 GA Drill and Fillet D3208-7 corner as per Dwg D3208 CFI O4-12-15 4 8 GA Deburr D3208-3 corner as per Dwg D3208 CFI O4-12-15 4 9 GB Form D3208-1/-3/-7 CFI O4-12-15 4 9 GB Form D3208-1 as per Dwg D3208 CFI O4-12-15 4 10 GB Form D3208-3 as per Dwg D3208 CFI O4-12-15 4 11 QC5 Inspect work to Step 10 CFI O4-12-15 4 12 FP Chemical Conversion Coat as per QSI 005 4.1 CFI O4-12-15 4 13 QC3 Inspect Conversion Coat CFI O4-12-15 4 14 ST Identify and Stock D3208-1 Qty			(M606116S.063)	C 1	11216	Δ
Identify as D3208-1			1	CPL	04-12-17	1
6 GA Drill and Fillet D3208-7 corner as per Dwg D3208 Identify as D3208-7 CPL 04-12-15 4 7 GA Drill and Fillet D3208-3 corner as per Dwg D3208 Identify as D3208-3 CPL 04-12-15 4 8 GA Deburr D3208-1/-3/-7 CPL 04-12-15 4 9 GB Form D3208-1 as per Dwg D3208 O5-01-05 4 10 GB Form D3208-3 as per Dwg D3208 O5-01-05 4 11 QC5 Inspect work to Step 10 O5-01-10 4 12 FP Chemical Conversion Coat as per QSI 005 4.1 O5-01-10 4 13 QC3 Inspect Conversion Coat D3208-1 Qty	5	GA	l	CZI	01/17/5	1
Identify as D3208-7		GΔ		-ir	04-12-13	4
7 GA Drill and Fillet D3208-3 corner as per Dwg D3208 Identify as D3208-3 D4-12-15 4 8 GA Deburr D3208-1/-3/-7 CPL 04-12-15 4 9 GB Form D3208-1 as per Dwg D3208 CPL 04-12-15 4 10 GB Form D3208-3 as per Dwg D3208 CPL 04-12-15 4 11 QC5 Inspect work to Step 10 CPL 04-12-15 4 12 FP Chemical Conversion Coat as per QSI 005 4.1 CPL 04-12-15 4 13 QC3 Inspect Conversion Coat CPL 04-12-15 4 14 ST Identify and Stock D3208-1 Qty: 4 CPL 04-12-15 4 15 AC Parts to Stock and Prorate cost to parts per Step 20 Cost / part / 4 , 46 14 / 7 / 7 Suc 25-0/-12 Step 11 4 16 DC Close W/O 7 · 80 7 · 34 7 · 47 1 / 7 1 / 7		GA.	,	PPI	04-17-16	4
Identify as D3208-3	7	GA			- ()	<i>J</i> :
9 GB Form D3208-1 as per Dwg D3208 10 GB Form D3208-3 as per Dwg D3208 11 QC5 Inspect work to Step 10 12 FP Chemical Conversion Coat as per QSI 005 4.1 13 QC3 Inspect Conversion Coat 14 ST Identify and Stock D3208-1 Qty: D3208-3 Qty: D3208-7 Qty: D3208-7 Qty: D3208-7 Qty: D3208-7 Qty: D3208-7 Qty: D3208-7 Qty: D3208-1 Qty: D3208-7 Qty:				CPC	04-12-15	4
9 GB Form D3208-1 as per Dwg D3208 10 GB Form D3208-3 as per Dwg D3208 11 QC5 Inspect work to Step 10 12 FP Chemical Conversion Coat as per QSI 005 4.1 13 QC3 Inspect Conversion Coat 14 ST Identify and Stock D3208-1 Qty: 4 D3208-7 Qty: 4 D5-01-05 M D5-01-11 M D5-01-11 D5-01-12 D5-01-15 D5-01-	8	GA	Deburr D3208-1/-3/-7	- 00		Á
10 GB Form D3208-3 as per Dwg D3208 11 QC5 Inspect work to Step 10 12 FP Chemical Conversion Coat as per QSI 005 4.1 13 QC3 Inspect Conversion Coat 14 ST Identify and Stock D3208-1 Qty: D3208-3 Qty: D3208-7 Q				CPL	04-12-15	4
10 GB Form D3208-3 as per Dwg D3208 11 QC5 Inspect work to Step 10 12 FP Chemical Conversion Coat as per QSI 005 4.1 13 QC3 Inspect Conversion Coat 14 ST Identify and Stock D3208-1 Qty: D3208-3 Qty: D3208-7 Q	9	GB	Form D3208-1 as per Dwg D3208 ,	1/	05-01-05	· •/
11 QC5 Inspect work to Step 10 12 FP Chemical Conversion Coat as per QSI 005 4.1 13 QC3 Inspect Conversion Coat 14 ST Identify and Stock D3208-1 Qty: 4 D3208-7 Qty: 4 D	10	O.D.	F D2000 2 D2200	1		
12 FP Chemical Conversion Coat as per QSI 005 4.1 13 QC3 Inspect Conversion Coat 14 ST Identify and Stock D3208-1 Qty: D3208-3 Qty: D3208-7 Qty:	10	GB	Form D3208-3 as per Dwg D3208	14	05-01-05	4
12 FP Chemical Conversion Coat as per QSI 005 4.1 13 QC3 Inspect Conversion Coat 14 ST Identify and Stock D3208-1 Qty: D3208-3 Qty: D3208-7 Qty:	11	OC5	Inspect work to Step 10	10		
12 FP Chemical Conversion Coat as per QSI 005 4.1 13 QC3 Inspect Conversion Coat 14 ST Identify and Stock 15 D3208-1 Qty: 16 DC Close W/O 7.80 7.34 7.47	''	400	This poor work to otop 10		25.01.10	4
13 QC3 Inspect Conversion Coat 14 ST Identify and Stock 15 AC Parts to Stock and Prorate cost to parts per Step 20 Cost / part / 4,46 / 140 / 14,72 16 DC Close W/O 7.80 7.34 7.47	12	FP	Chemical Conversion Coat as per QSI 005 4.1	MC,		. 1
14 ST Identify and Stock D3208-1 Qty: 4 D3208-3 Qty: 4 D3208-7 Qty: 4 D5/6/11/1 4 15 AC Parts to Stock and Prorate cost to parts per Step 20 Cost / part 14,46 1401 14,72 S4C &-0/-/2 \$\frac{14}{9}\$ Close W/O 7.80 7.34 7.47					05-01-11	4
14 ST Identify and Stock D3208-1 Qty: 4 D3208-3 Qty: 4 D3208-7 Qty: 4 D3208-7 Qty: 4 D5/0/// D3208-7 Qty: 4 D5/0//// D3208-7 Qty: 4 D5/0//// D3208-7 Qty: 4 D5/0/////// D3208-7 Qty: 4 D5/0///////////////////////////////////	13	QC3	Inspect Conversion Coat	All Sall	TC 21 11	11
D3208-3 Qty: 4 D3208-7 Qty: 4 D3208-7 Qty: 4 D3208-7 Qty: 4 D3208-7 Qty: 4 D5/0/// 15 AC Parts to Stock and Prorate cost to parts per Step 20 Cost / part 1 4 4 6 14 0 1 14 7 2 Close W/O 7 8 0 7 34 7 47	144	CT.	I Harriff and Otack Doctor	<i> </i> (_	UD () 11	7
D3208-7 Qty: 4 C3 05/01/11 4 15 AC Parts to Stock and Prorate cost to parts per Step 20 Cost / part 14,46 140 14,72 540 55	14	51		l n		
15 AC Parts to Stock and Prorate cost to parts per Step 20 Cost / part 14,46 1401 14,72 540 05-0/-12 5 16 DC Close W/O 7.80 7.34 7.47	1			10 d	osloilu	Ц
Cost / part 14.46 14.01 14.12 540 $05-01-12$ 9	15	AC		- 00	-0101111	1
16 DC Close W/O 7.8° 7.34 7.47	.	,		500	05:01-17	(/
Inspect Level 21.	16	DC		11/V	3 3/-/ 6	<u> </u>
1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	L		Inspect Level 21	4	05.01.12	4

Rev	Date	Change	Revised By	Approvee
Α	04.04.15	New issue	KJ/RF	7/1
В	04.05.25	Material changed for Step 4	KJ/JLM ' (



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES												
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector							
					-									
NCR:		WORK ORDER NON-CON	FORMANCE (NC	R)										

CR: WORK ORDER NON-CONFORMANCE (NCR)								
	Description of NC		Corrective Action Section B		Varification	Annroval	Approval	
STEP	Section A	Initial Design Mgr	Action Description Design Mgr	Sign & Date	Section C	Design Mgr	QC Inspector	
			•					
	-							
	STEP	STED Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Corrective Action Section B Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Description of NC Section A Initial Action Description Sign & Section C	STEP Description of NC Section A Initial Corrective Action Section B Initial Action Description Sign & Section C Section C Section C Section C Design Mgr	

Part No:	PAR #:	Fault Category:	NCR:	Yes	No	DQA:	Date:	.10
NOTE: Date & initial all entries				QA:	N/C C	losed:	Date:	

Job Costing Report

Dart	Aerospace	Ltd.
	esburv	

Dec 06, 2004 11:09 am

Work Order No : 0022080 Project Name : D3208-7 Project For : WK503 Burden Flags Work Order Type : Main WO Status Main WO Number Invoice Date House Part Number: D3208-7 Invoice Number:

Description : Filler Manufactured : Yes

Amount Req'd: Amount Done : 0

Start Date : 12-06-04 Est Finish Date : 01-15-05

Act Finish Date Drawings Reqd : No Ok for Approval :

Approval Rec'd

Department Code:

: NNNNNNN : Open

Invoice State : Not Invoiced

Invoice Amount : 0.00

Order Entry No:

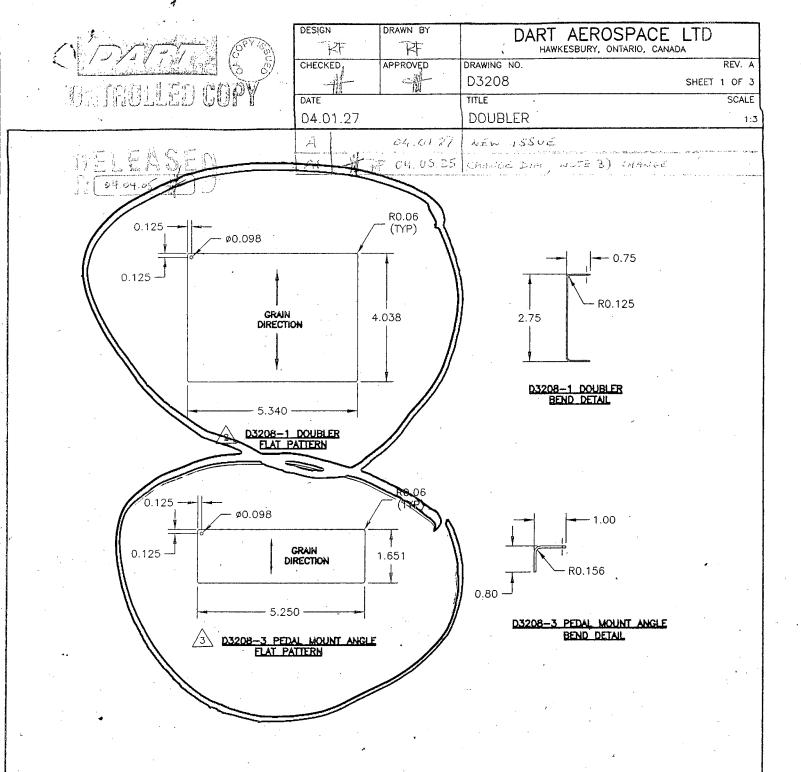
0.00 OE Value

Est Margin 0.000% Actual Margin : 0.000%

\$0 Posted to Finished Goods

		Estimated	·	Actual	Var. %	. 	Posted	To Post
Material Cost		0.00	,	0.00	0.00		0.00	0.00
Engineering Hours	:	0.00		0.00	0.00			
Engineering Cost	:	0.00	. •	0.00	0.00		0.00	0.00
Production Hours	:	0.00	٠,	0.00	0.00			
Production Cost	:	0.00	ŧ	0.00	0.00		-0.00	0.00
Packaging Hours	:	0.00		0.00	0.00			
Packaging Cost	:	0.00		0.00	0.00		0.00	0.00
OverHead Hours	:	0.00		0.00	0.00			
OverHead Cost	:	0.00		0.00	0.00		0.00	0.00
CNC Hours	:	0.00		0.00	0.00			
CNC	:	0.00		0.00	0.00		0.00	0.00
Misc. Hours	:	0.00		0.00	0.00			
Misc.	:	0.00		0.00	0.00		0.00	0.00
		========	===	======	=======		•	
Burden	:	0.00		0.00	0.00			•
		=======	===	=====	======			
Total Cost	:	0.00		0.00	0.00			
Margin	:	0.000	,	0.000				•
Selling Cost	:	0.00		0.00				

Estimated Actual Labour Hrs/Amount Done 0.00 0.00 Profits/(Loss) . 0.00 0.00

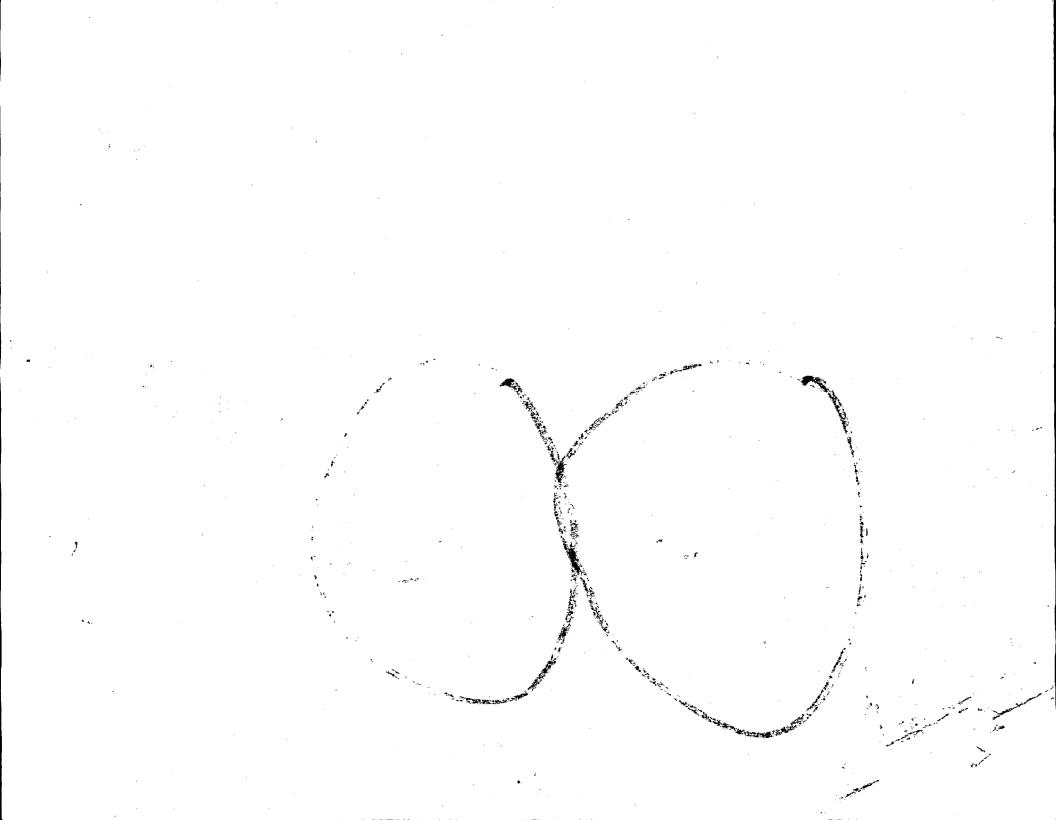


NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 2) MATERIAL: 2024—T3 (QQ—A—250/4) 0.040" THICK (M2024T3S.040) 3)—MATERIAL: -2024—T3 (QQ—A—250/4)—0.063" THICK (M2024T3S.063) 4) MATERIAL: 2024—T3 (QQ—A—250/4) 0.080" THICK (M2024T3S.080) 5) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

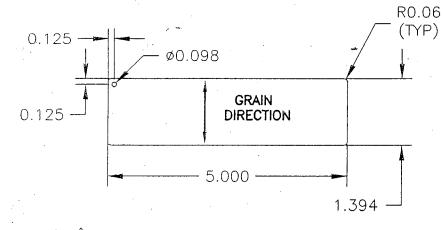
3) MATCHIAL - 620,-TE (EQ - K-250/H) 0.063" THICK (MCOCK TEXICES)



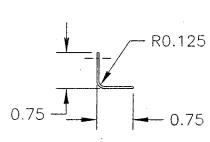


	DESIGN	DRAWN BY		T AEROSPACE LTD AWKESBURY, ONTARIO, CANADA	
ľ	CHECKED.	APPROVED	DRAWING NO.		REV. A
ĺ		#	D3208 ,	SHEET	2 OF 3
T	DATE		TITLE		SCALE
	04.01.27		DOUBLER		1:2

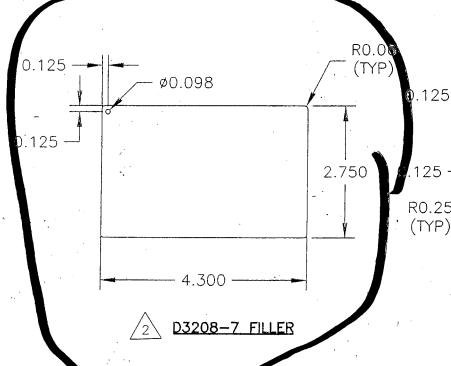


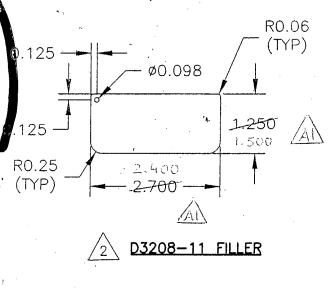


D3208-5 MOUNT ANGLE



D3208-5 MOUNT ANGLE BEND DETAIL





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